Work Order ID 90079

September-13-12 1:01:17 PM

90079

Item ID: D3259-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Doubler

Start Date: 9/12/12 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 10/05/12 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 12-09-13 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3259	Rev B								RB12-10-7
100	FLOW WATER JET	0.00				8			
100	**Memo**	0.00							
Waterjet	1-Cut as per Dwg D3259 Dwg Rev: B Prog Rev: B 2- Deburr if necessary								
FLOW CNC Waterjet									
2024 .063"									
110	QC2- Inspect parts off machine FAI/FAIB	0.00				8		RB12-10-7	
110	**Memo**	0.00							
QC									
Quality Control									
120	QC8- Inspect parts - second check	0.00				8			
120	**Memo**	0.00 SMB 12.10.09							
QC									
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Work Order ID 90079

September-13-12 1:01:17 PM

90079

Item ID: D3259-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Doubler

Start Date: 9/12/12 **Start Qty:** 6.00 *6*

Required Date: 10/05/12 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					8X			12/12/17
Small Fab	**Memo**	0.00							
Small Fab	1-C'Sink Holes as per Dwg D3259								
140		0.00							8
140	NC BRAKE					8			13 Dec 22
Brake NC	**Memo**	0.00							
Brake NC	Form as per Dwg D3259								
150	QC5- Inspect part completeness to step on W/O	0.00							JAS 15 9-89
150						8			13 Dec 22
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped.
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio

☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions

☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Item ID: D3259-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Doubler

Start Date: 9/12/12 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 10/05/12 **Req'd Qty:** 6.00 *6* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						8	NG	13-1-22	
HandFinish	**Memo**	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00 DAS 15 9-69							
170						8			
QC	**Memo**	0.00 B1.23							
Quality Control									
180	Identify as per dwg & Stock Location: ST 180A	0.00							
180						8			13-01-23 JS
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

_____

_____

_____

Item ID: D3259-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Doubler

Start Date: 9/12/12 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 10/05/12 **Req'd Qty:** 6.00 *6* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00					13	1	25
190									
QC	**Memo**	0.00							
Quality Control									

MF 13-1-25

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric to O/S
☐ Cracks
☐ Crushed/Crimped.
☐ Cuffs
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Ripples in Bend
☐ Torque Waves in Extrusion
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damaged
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drill Holes
☐ Drawing
☐ Finish
☐ Folio
☐ Grain
☐ Hardware
☐ Inspection Incomplete
☐ Instructions Incomplete/Unclear
☐ Maintenance
☐ Mislabeled
☐ Misread
☐ Offset
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Ovalized
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

September-13-12 1:01:17 PM

Work Order ID: 90079

Parent Item: D3259-3

Parent Item Name: Doubler

Start Date: 9/12/12 **Required Date:** 10/05/12

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	106.0200	**1.388**	**8.7663156**	8	12-10-7	

Location	Loc Qty	Loc Code
MAT022	106.02	
119916	62.6	
121197	43.42	

119916

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Work Order Update ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric to O/S
- ☐ Cracks
- ☐ Crushed/Crimped.
- ☐ Cuffs
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Ripples in Bend
- ☐ Torque Waves in Extrusion
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damaged
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drill Holes
- ☐ Drawing
- ☐ Finish
- ☐ Folio
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete
- ☐ Instructions Incomplete/Unclear
- ☐ Maintenance
- ☐ Mislabeled
- ☐ Misread
- ☐ Offset
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Ovalized
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

DART AEROSPACE LTD	Work Order:	90079
Description: Doubler	Part Number:	D3259-3/-4
Inspection Dwg: D3259 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

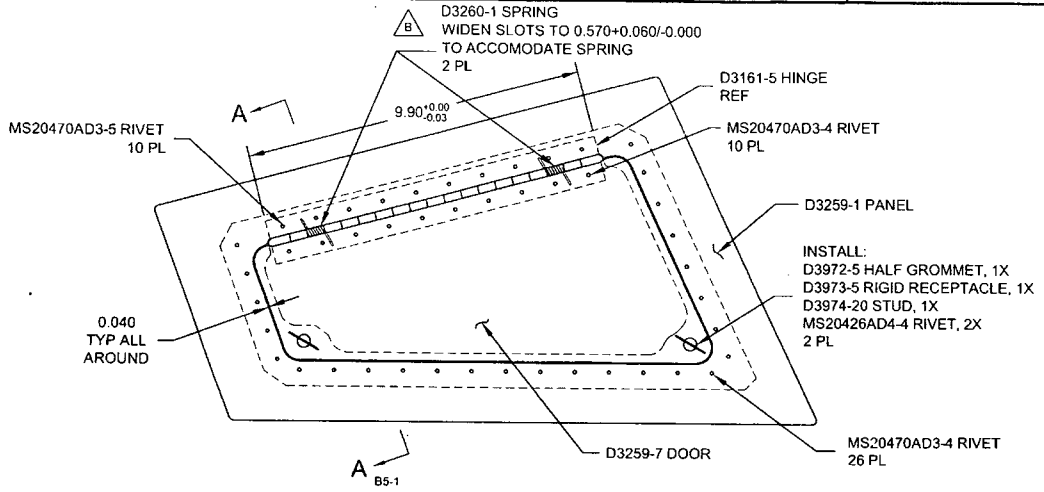
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
9.000	+/-0.005	9.001	2		PRO WSR	
1.000	+/-0.005	.999	2		V 1802	
0.260	+/-0.010	.258	2		V	
R0.25	+/-0.030	.25	2		R. G.	
R0.50	+/-0.030	.50	2		R. G.	
5.000	+/-0.005	5.002	2		V	
0.875	+/-0.005	.873	2		V	
12.000	+/-0.005	12.001	2		P	
3.500	+/-0.005	3.499	2		V	
0.875	+/-0.005	.875	2		V	
R0.13	+/-0.030	.13	2		R. G.	
0.500	+/-0.005	.501	2		V	
0.525	+/-0.005	.524	2		V	
1.80	+/-0.030	1.801	2		V	
Ø0.128	+0.005/-0.000	.133	2		V	
Ø0.377	+0.005/-0.000	.379	2		V	
Ø0.098	+0.005/-0.000	.101	2		V	
0.063 thick	+/-0.005	.064	2		V	
Grain Direction	N/A		N/A			

Measured by:	B
Date:	12-10-4

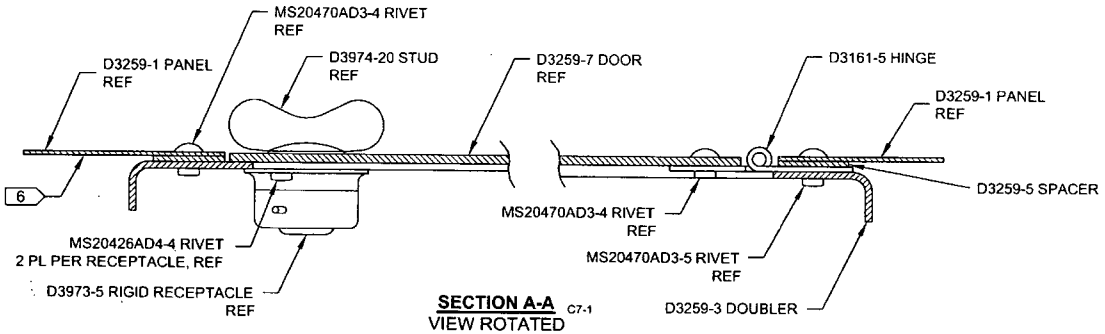
Audited by:	SMB
Date:	12.10.09

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	
C	10.08.03	Dimensions updated	KJ	



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



SECTION A-A C7-1
VIEW ROTATED
NOT TO SCALE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 90079 MLJ
12-09-13

RELEASED
2009 -10- 08

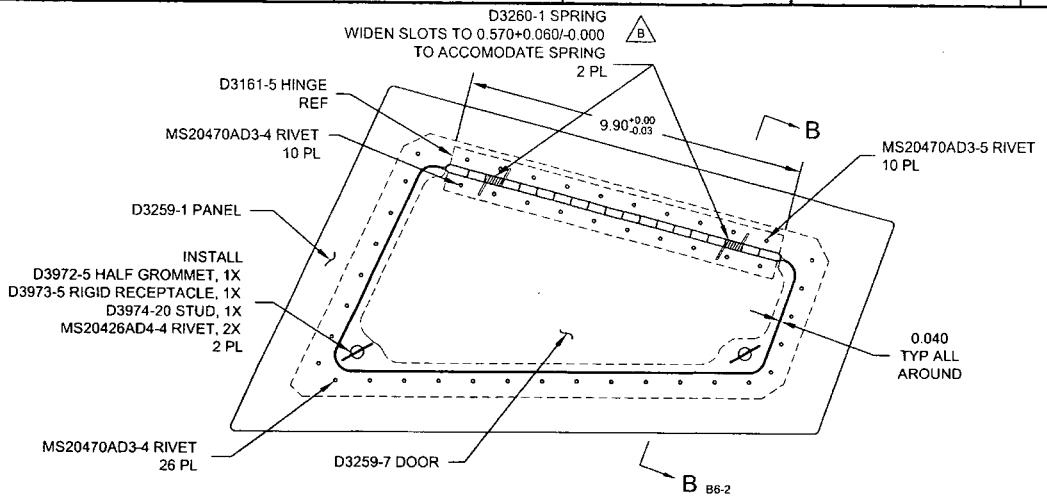
D3259-041 ACCESS PANEL ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
7) WEIGHT: 1.2 lbs

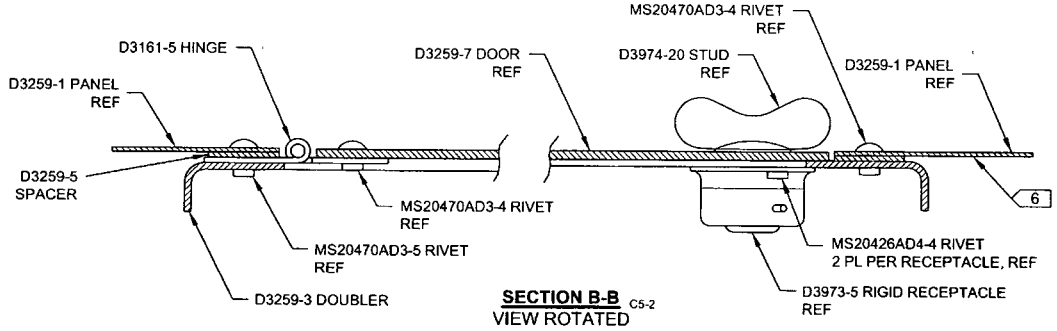
REV.	DESCRIPTION	BY	DATE
B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)	CP	09.08.12
A	NEW ISSUE	CP	04.02.25

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
DATE	09.08.12		

90079



ITEM	QTY -042	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



SECTION B-B C5-2
VIEW ROTATED

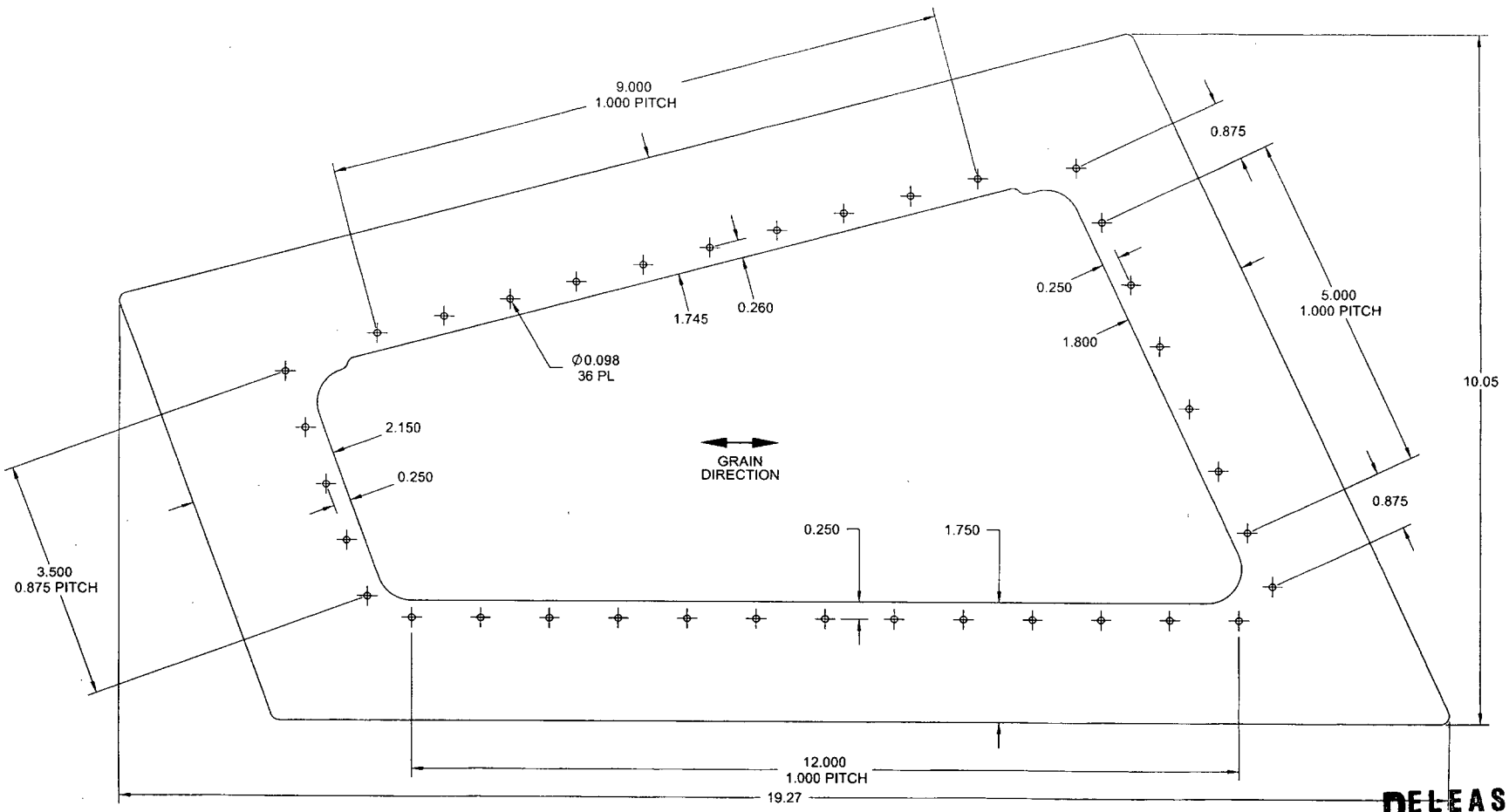
D3259-042 ACCESS PANEL ASSEMBLY

RELEASED
2009 -10- 08

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: NONE
6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
7) WEIGHT: 1.2 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B
MFG. APPR.		SHEET 2 OF 8
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE	09.08.12	

90079



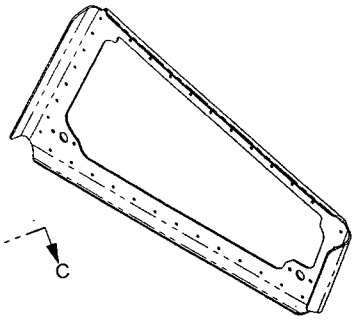
D3259-1 PANEL

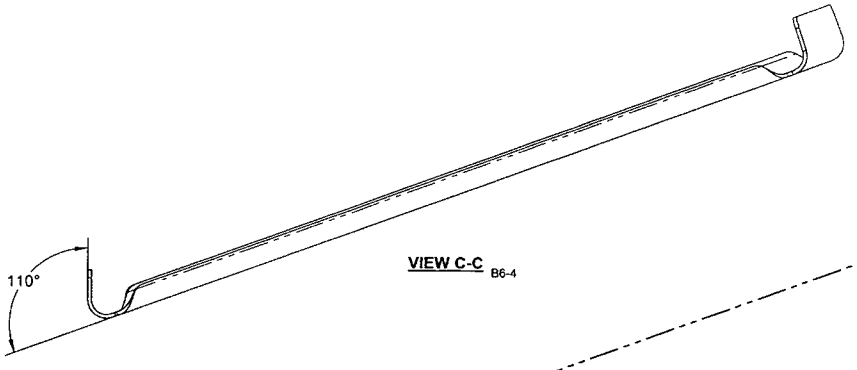
RELEASED
2009 -10- 08

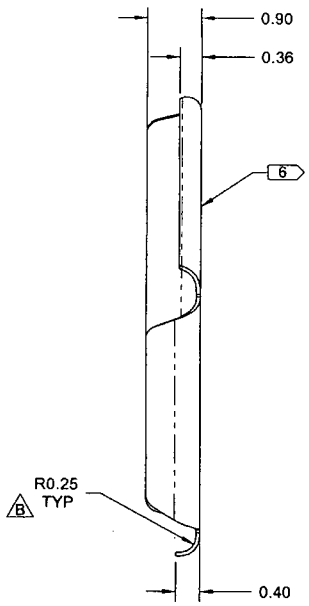
NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
7) WEIGHT: 0.25 lbs
8) MAKE PER DWG FILE "D3259-1B.DXF

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B SHEET 3 OF 8
MFG. APPR.		
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		

9.0079







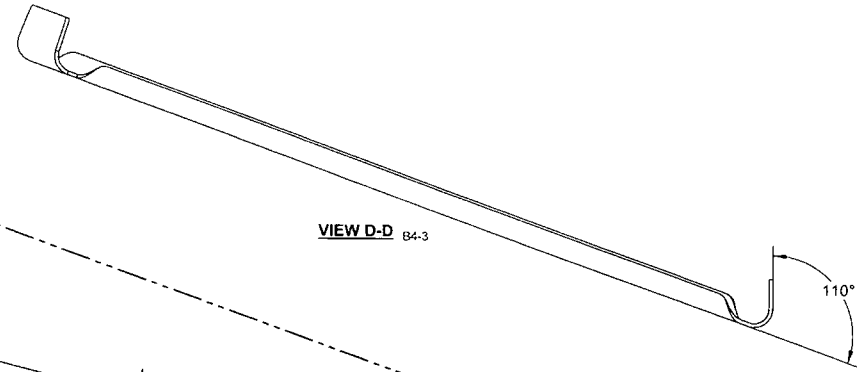
D3259-3 DOUBLER

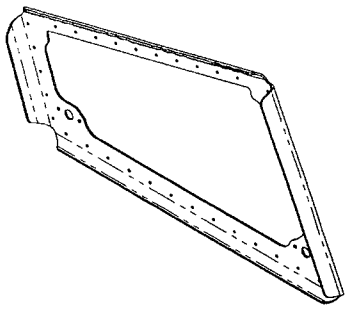
RELEASED
2009 -10- 08

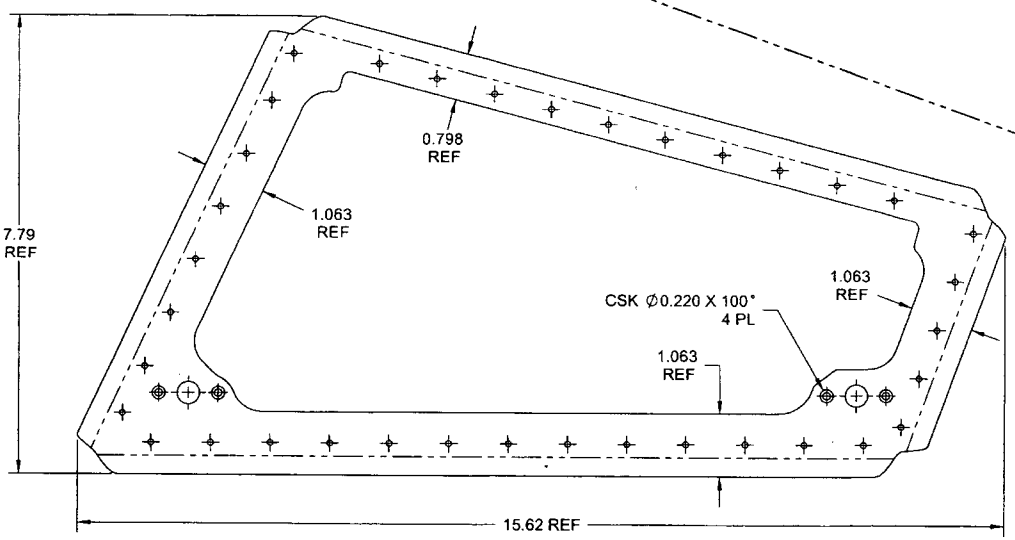
NOTES:
1) MATERIAL: MAKE FROM D3259-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3" USING REMOVABLE TAG
7) WEIGHT: 0.31 lbs

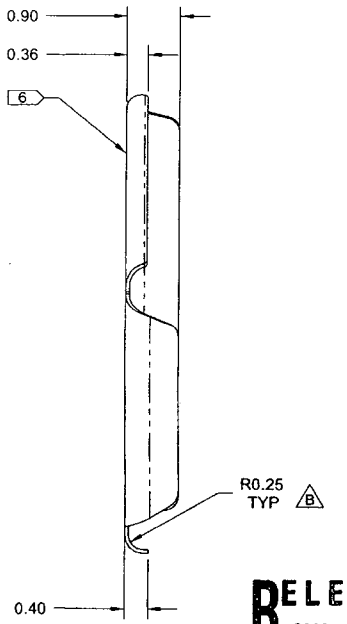
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B SHEET 4 OF 8
MFG. APPR.		
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		

90079









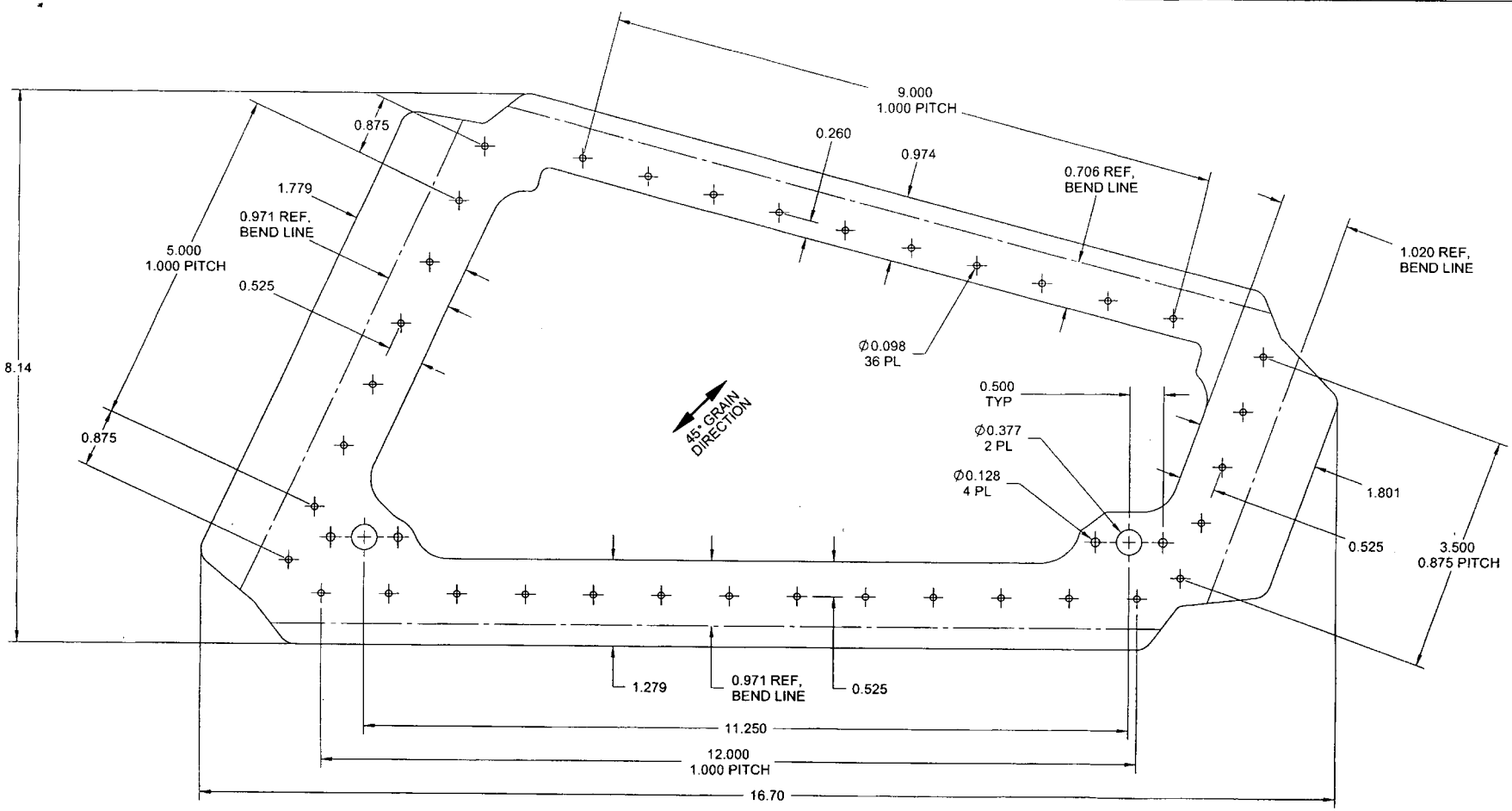
D3959-4 DOUBLER

RELEASED
2009 -10- 08

NOTES:
1) MATERIAL: MAKE FROM D3259-3F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3959-4" USING REMOVABLE TAG
7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B SHEET 5 OF 8
MFG. APPR.		
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		

90079



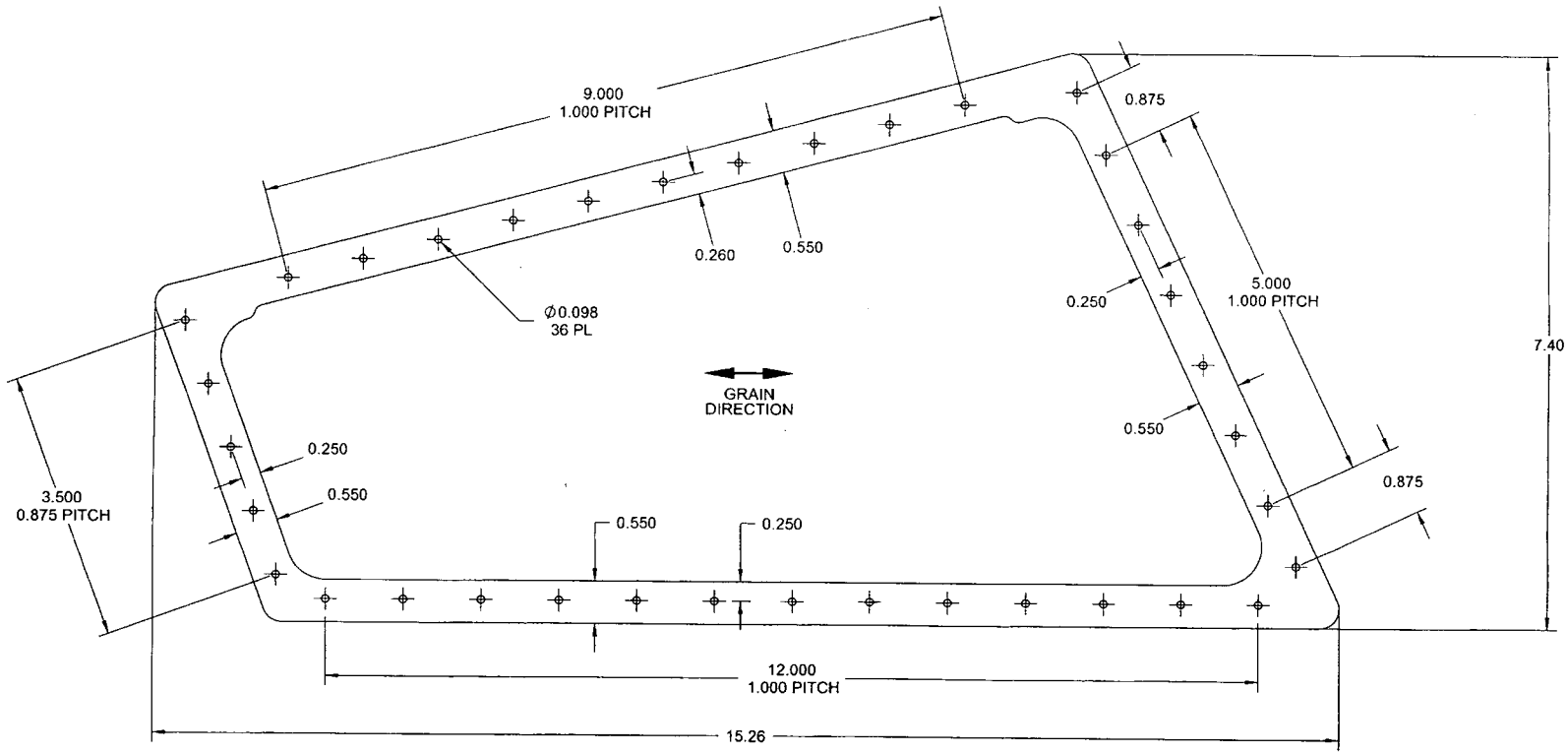
D3259-3F DOUBLER

RELEASED
2009 -10- 08

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
7) WEIGHT: 0.31 lbs
8) MAKE PER DWG FILE "D3259-3FB.DXF

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B
MFG. APPR.		SHEET 6 OF 8
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		

90079



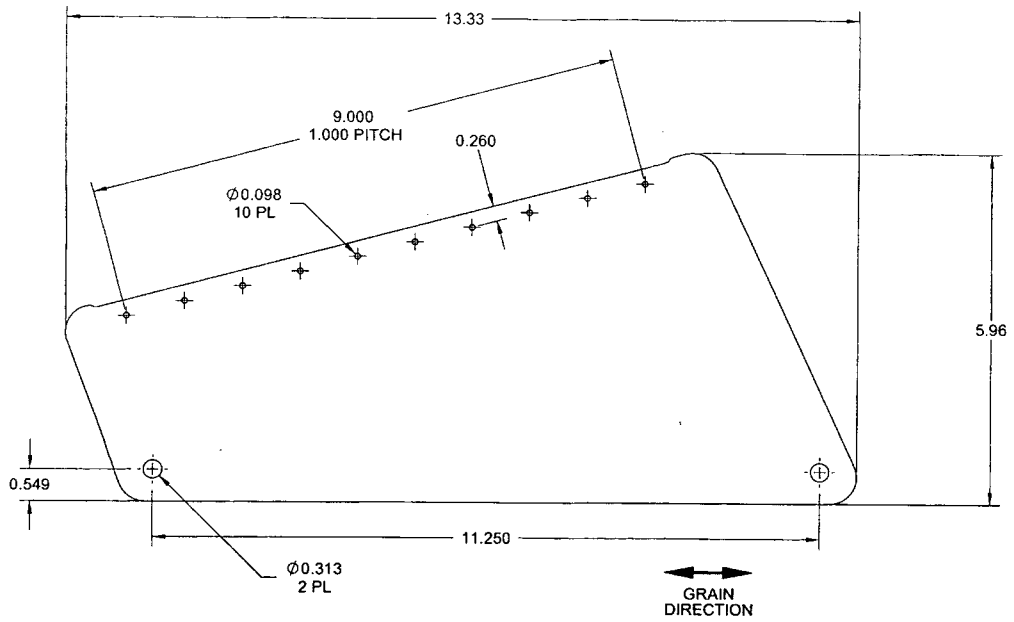
D3259-5 SPACER

RELEASED
2009 -10- 08

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
7) WEIGHT: 0.07 lbs
8) MAKE PER DWG FILE "D3259-5B.DXF

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B
MFG. APPR.		SHEET 7 OF 8
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		

90079



D3259-7 DOOR

RELEASED
2009 -10- 08

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
7) WEIGHT: 0.35 lbs
8) MAKE PER DWG FILE "D3259-7B.DXF

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3259 REV. B
MFG. APPR.		SHEET 8 OF 8
APPROVED		TITLE ACCESS PANEL ASSEMBLY SCALE NTS
DE APPR.		
DATE 09.08.12		